Work Order January-07-14 3:0			*110749*										
Revision ID: Item Name: Sta	3535-33 ainless Steel Wearplate Aft 07/14	*R* *A*	Accept	*N900 Cust Item I Customer:		100)* s	etup Star Stop	14.71				
	Process Plan: MLJ	Date: 14-01-7			ate:	_	R	tun Star Stop	, "I <i>X</i> I	R1*			
(QC:	_ Date:	SPC (Y/N):	D:	ate:				*N	R2*			
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_		
Draw Nbr	Revision Nbr		,										
D3535	Rev B												
100 *1 \\ Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as p Deburr if r		0.00 0.00 : B Prog Rev: 1				_11_	_ပ		Ae 14.01	. 3		
*110 * QC Quality Control	QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				<u> </u>	<u>0</u>		<u>Ae</u> 14.01	.3		
120 *1 20* QC	QC8- Inspect parts - se Memo	₹ cond check	0.00 DAS 27 9-89	_			ij						

Quality Control

DQA:			Date:										_	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	or.					DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS		i
WOIK OIU	-					Rework]		Skid-tube Crosstube	<u></u>	1	Water Jet	٦	Engineering
Part f	do					Scrap			Machining Small Fat	_	Pro	d. Eng. Coor.	┪	Quality
	•		· · · · · · ·			Use-as-is			noforming Finishing	\vdash	-1	re/Packaging	7	Other
NCR I	۱o.					Suspected Unapproved]		Large Fab Composite	-]	Supplier		
Root		-			Desc	ription of work order update		nitial	Action		Sign &			· • ·
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design												Program.		
Doc/Data	Щ						}							
Equip/Tooling	Щ				•									
Handling/Pre	Ш						ļ							
Material	Щ						İ						Ì	
Operator	Щ										1			
Offset/Setup	\vdash												ı	
Process	Н	:												
Supplier	Н						1							
Training	\vdash					•								
Transport Unapproved	\vdash		1				١							
Onapproved			l	L	l		FΑ	UIT CA	TEGORY			I		
Landi	ng (Gear	· ·			General								·····
		Bending				Bend] Folio/F	Program		Outside Dim	ensions	٦	ressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	0.1	F	Over/Under	 		Set-up
	П	Cracks				Broken/Damage/Defect		Hardwa	are	\vdash	Part Incorre	-		emperature/Cure
		Crimp/Kit	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/M	issing	\neg	Veld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		٦	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	vist in Tub	oe e	.	Fit/Function		Out of	Sequence					

W	ork	Order	ID	110749
---	-----	-------	----	--------

110749

Page 2

January-07-14 3:02:31 PM Accept Setup Start Item ID: D3535-33 *N900040100* **Revision ID:** Stop Stainless Steel Wearplate Aft **Item Name:** Start Qty: 6.00 **Start Date:** 1/07/14 **Cust Item ID:** Req'd Qty: 6.00 Required Date: 1/07/14 **Customer:** Reference: Start Run Process Plan: Date:____ **Tooling:** Date: **Approvals:** Stop Date: SPC (Y/N): Date: QC: Reject Set Up/ **Tool ID** Tool # Plan Accept Reject Insp. Sequence ID/ Operation Code Qty Qty Number Stamp **Work Center ID** Description **Run Hours** DAS 0.00 130 30 NC BRAKE *130* 9-89 0.00 Brake NC 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326. 2-Brake NC Identify as D3535-33. DAS OC5- Inspect part completeness to step on W/O 140 *140* QC Memo **Quality Control** Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 150 11\$ H.D-5. *150* 0.00 Powdercoat Memo

Powder Coating

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			A	AGAINST DE	PARTMENT	PROCESS	
	•	•				Rework			Skid-tube Cr	rosstube]	Water Jet	Engineering
Part N	١o.					Scrap			Machining S	mall Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming 6	Finishing	Rec/Stor	e/Packaging	Other
NCR I	۱o. ِ					Suspected Unapproved			Large Fab Co	omposite]	Supplier	
Root					Desc	ription of work order update		nitial	Action		Sign &		[
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	on	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling]		
Handling/Pre	\square												
Material	\vdash												
Operator	Щ												
Offset/Setup	Н				ŀ								
Process Supplier	Н												
Training											ı		
Transport													
Unapproved													
	1		•		<u> </u>		FA	ULT CA	TEGORY				
Landi	ng (Gear				General							
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં	Temperature/Cure
i		Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Unqual	lified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		4	tions Incomplete/Uncle	ear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink	_	•	gned/off center		Positioned V		_
	_	Heat Trea				Cut Too Short		Mislabe			Power Loss/	Surge	Other
	_	Inspectio	•	Tube	<u> </u>	Drawing		Misrea					
	<u> </u>	Marks/Ch			<u> </u>	Drill Holes		Off-set					
	<u> </u>	Turning S			\vdash	Finish	_	4	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

Work Orde		10749		*110					Page 3		
Item ID: Revision ID: Item Name:	D3535-33 Stainless Stee	el Wearplate Aft		Accept	*N900	040	100)* s	etup Sta	IV	S1* S2*
Start Date: Required Date: Reference:	1/07/14 1/07/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:			S4	-	
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		nte:		K	Run Sta Sto	~ \	R1* R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo	1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 9
170 *17 Packaging Packaging		Identify as per dwg & St Memo	ock Location: FP	0.00				<u> </u>	4	Sl	<u>lozlo</u>

180

QC21- Final Inspection - Work Order Release

0.00

1 20

Memo

0.00

Quality Control

MLJ 14-02-05

DQA:			Date:										DA DT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT	Έ			AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AG	AINST DE	PARTMENT	PROCESS	
	-				_	Rework			Skid-tube Cros	sstube		Water Jet	Engineering
Part N	١o.					Scrap			—	all Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming Fin	nishing	Rec/Stor	e/Packaging	Other
NCR N	۱o.					Suspected Unapproved			Large Fab Com	posite		Supplier	
									<u> </u>	-		,	
Root					Desc	ription of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material				-									
Operator		'											
Offset/Setup													
Process													
Supplier													
Training													
Transport +			1 .				ļ						
Unapproved													
							FA	ULT CA	TEGORY			a,	
Landi	ng (Sear			_	General		-			-		_
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks			L	Broken/Damage/Defect	L	Hardwa	are		Part Incorred	i	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	L	Burrs		Inspect	ion Incomplete/Unqualific	ed	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing			L	Countersink		Misalig	gned/off center		Positioned V	/rong	_
,		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Picklist Print

January-07-14 3:02:30 PM

Work Order ID:

110749

Parent Item:

D3535-33

Parent Item Name:

Stainless Steel Wearplate Aft

Start Date: 1/07/14

Required Date: 1/07/14

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	298.5500	0.6445	4.070526	6	Ae	14.01.3
				Location		Loc Qty	Lo	c Code					
				MAT020		298.55							
				m1268	352	7.75					,	- 0	
				m1274	154	290.8				745 4	$t \rightarrow$	83	ϵ

age 1

DQA:			Date:										•	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Orde	er:					DISPOSITION			AGAINS	ΓDE	PARTMENT	/PROCESS		
	•					Rework	1		Skid-tube Crosstube	٦	1	Water Jet		Engineering
Part N	۱o.					Scrap			Machining Small Fal		Pro	d. Eng. Coor.		Quality
						Use-as-is		Therr	moforming Finishing	3	Rec/Sto	re/Packaging		Other
NCR N	۱o. ِ		- 11-			Suspected Unapproved]		Large Fab Composite	=]	Supplier		
Root					Desc	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	.	QC Inspector
Design													Ī	
Doc/Data												1		
Equip/Tooling													1	
Handling/Pre														
Material													١	
Operator														
Offset/Setup														
Process														
Supplier											·]			
Training														
Transport	\vdash													
Unapproved	L		L .					III T CA	TECODY		<u> </u>	<u>, , , , , , , , , , , , , , , , , , , </u>		
l andi						·····	FA	ULI CA	TEGORY					
Landi		Bending				General Bend]	Program		Outside Dim	ansians [\neg	Pressure/Forced
	\vdash	Centre No	ot Concer	ntric	-	BOM/Route	-	Grain	riogiani	\vdash	Over/Under	⊢		Set-up
	_	Cracks	or concer	ICIIC	-	Broken/Damage/Defect	-	Hardwa	are.	\vdash	Part Incorred	⊢	_	Temperature/Cure
	_	Crimp/Kir	nk/Rinnle	/Wave	-	Burrs	\vdash	4	tion Incomplete/Unqualified	\vdash	Part Lost/Mi	<u>-</u>		Weld
ī	\vdash	Cuffs	пу прріс	, wave		Contamination		1 '	tions Incomplete/Unclear	-	Part Moved	-	\neg	Wrong Stock Pulled
		Crushing			-	Countersink	-	4	gned/off center	\vdash	Positioned V	L Vrong		ong otock i uncu
		Heat Trea				Cut Too Short		Mislab	=		Power Loss/			Other
	Г	Inspectio		Tube		Drawing	\vdash	Misrea			_ · · · · · · · · · · · · · · · · · · ·	0-		
		Marks/Ch	•			Drill Holes		Off-set						
		Turning S				Finish		4	Calibration					· · · · · · · · · · · · · · · · · · ·
		Wave/Tw				Fit/Function		1	Sequence					

DART AEROSPACE LTD	Work Order:	110749
Description: Wearshoe	Part Number:	D3535-33
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	381.			V	JEM NOS
0.300	+/-0.010	.302	_		v	
0.300	+/-0.010	.307	,		V	
1.885	+/-0.010	1.085			V	
2.000	+/-0.010	2.000	_		V	
6.000	+/-0.010	6.000	_		1	DKm 06
9.500	+/-0.010	9,500	_		7	
15.250	+/-0.010	15.250	_		Τ	
21.000	+/-0.010	21.000			T	
24.500	+/-0.010	24.500	_		7	
6.00	+/-0.030	6.00	_		Ţ.	
6.75	+/-0.030	6.75	_		Ť	
13.50	+/-0.030	13.50			T	
0.040	+/-0.010	1035			V	
						:-
		·		 		2
						. •

Measured by: Ae

Date: 14.51.31

Date: 14.51.31

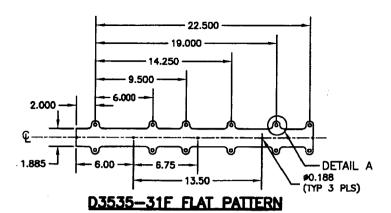
Date: Date: Date: N/A

Rev	Date	Change	Revised by	Approved
Α	09.10.16	New Issue	KJ KJ	177
			17/	

42.40.10

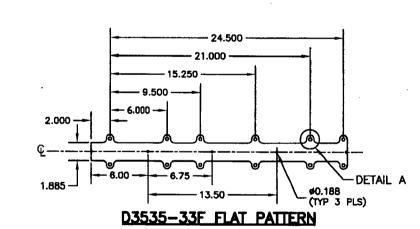
RELEASE







D3535-31 BEND DETAIL



D3535	5-33 BI	END DE	ΓΑΙΙ	

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

봀

DOCUMENT

ភ

OR COPIED

AEROSPACE PORT HADLOCK,

USA, RC.

SHEET 4 OF 7 REV.

SCALE 1:10

07.04.17

WEARSHOE

B

#

CHECKED

DRAWING NO. D3535

DART

07.04.24

RELEASE



CHECKED

APPROVED

D3535 DRAWING NO. B

B

DART

AEROSPACE PORT HADLOCK,

≸

USA,

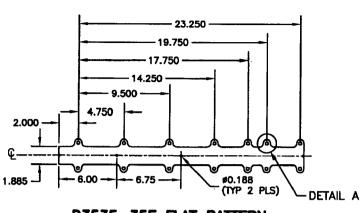
₹

RP

DATE

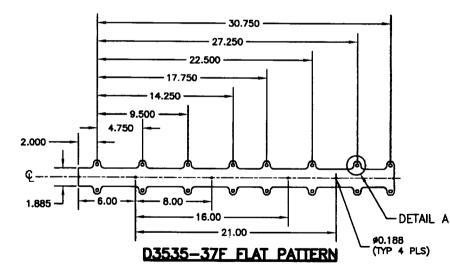
07.04.17

WEARSHOE



D3535-35F FLAT PATTERN





r .

캪

DOCUMENT

ᄶ

Copyright © 2006 by DART AEROSPACE USA, INC.

PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

PURPOSE

욹

COPIED

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

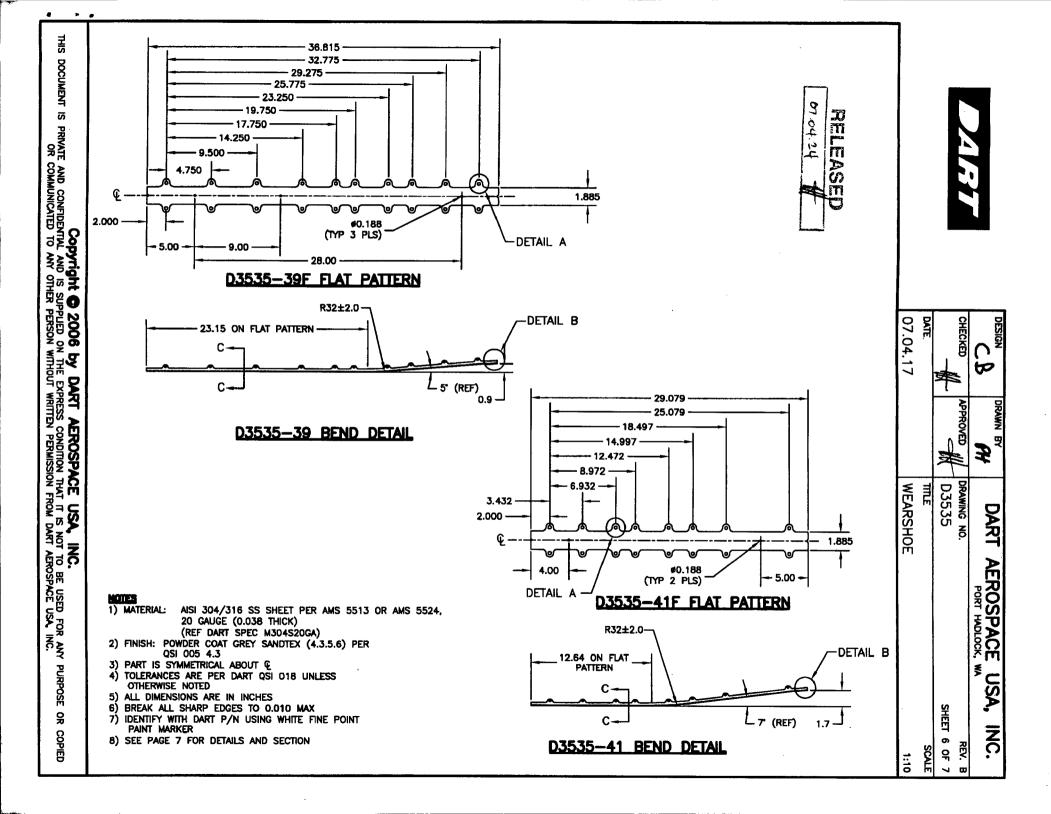
6) BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

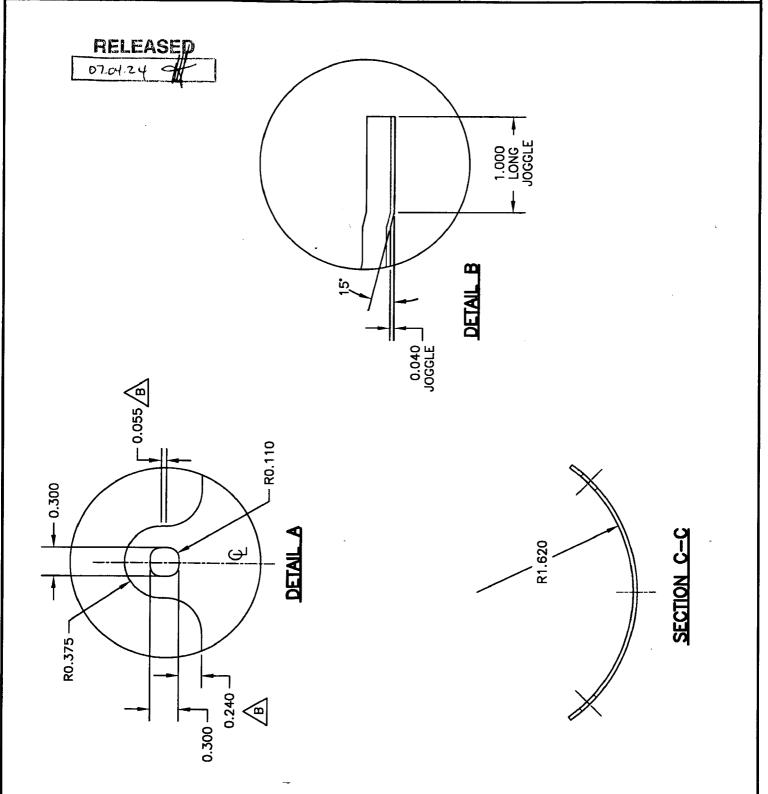


5 OF SCALE 1:10





CB CB	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED	APPROVED #//	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17	•	WEARSHOE	1:1



Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.